


VdTÜV-Kennblatt for welding consumables

		1 Manufacturer/Supplier MIGAL.CO GmbH Wattstraße 2 DEU 94405 Landau / Isar			2 No. of VdTÜV-Kennblatt: 12148.01 13.10.2017	
		3 Welding consumable*: Drahtelektrode				
4 Trade name*: ML 23.12 LSi (DE)						
7 Type*: EN ISO 14343-A - G 23 12 LSi						
11 Diameter range: 1,0 - 1,6 mm						
12 Auxiliary materials: EN ISO 14175 - M12, M13						
13 The validity of this Kennblatt will be certified, respectively, in the latest edition of CD-ROM TÜV-eignungsgeprüfte Schweißzusätze						
15 Materials and postweld heat treatment						
Pos	Wb	Group / Material 1	Text	Group / Material 2	Remarks	
A	U	Gruppe 8.1	verschweißt mit	Gruppe 1.1		
16 Material groups acc. to CR ISO 15608						
21 Root weldability: not verified						
23 Wall thickness: 30mm						
24 Type of current and polarity: G+						
25 Welding position according to DIN EN ISO 6947:1997-05: PA, PB, PC, PF						
26 Highest operating temperature in the short-term range as for parent metal, but not higher than:					350°C	
27 Highest operating temperature in the long-term range max.:					- - - °C	
28 Lowest operating temperature/as for parent metal, but not lower than:					-60°C	
29 Design stress value/as for parent metal:				wie Grundwerkstoff		
30 For use in the long-term range:				- - -		
31 Resistance to intergranular corrosion proven in accordance with:				- - -		
32 Remarks:						
33 The approval test was done on the basis of VdTÜV-Merkblatt 1153. Where nothing different is said under the heading -Remarks-, this welding consumable is suitable provided Annex I Point 4 of the Pressure Equipment Directive 97/23/EC is observed.						
34 Explanations		A tempered L solution annealed and quenched N normalized	S stress-relieved St stabilized U non-annealed V hardened and tempered	W soft annealed	G+ direct current plus pole G- direct current minus pole W alternating current	
35 Compiled in accordance with the data of: TÜV Rheinland						
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*) Statements of the manufacturer